

Work Order ID 152158

Friday, October 21, 2016 8:08:38 AM

152158

Page 1

Item ID: D2010-104 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: ARM
Start Date: 10/21/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 10/28/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-09** Date: **OCT 21 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								
100	NC BRAKE	0.00							
100									
Brake NC	Memo	0.23							
Brake NC	Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.27							
Small Fab	1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr ends								
120	Small Fab	0.00							
120									
Small Fab	Memo	0.14							
Small Fab	1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010								

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WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			DAS 38 9-89 NOV 01 2016
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <u>M 109777</u> Memo START TIME: <u>2:25</u> OVEN TEMPERATURE: <u>200</u> FINISH TIME: <u>2:55</u>	0.00 0.01				<u>4</u>	<u>0</u>	<u>16-11-9</u>	DAS 38 9-89 NOV 01 2016
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>4</u>			DAS 38 9-89 NOV 10 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>81351</u>	0.00							
160									
Packaging	Memo	0.01				4X		NOV 14 2016	DAS 26 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.07						NOV 14 2016	DAS 21 9-89
Quality Control									
								NOV 14 2016	DAS 21 9-89

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, October 21, 2016 8:08:41 AM

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Work Order ID: 152158

152158

Parent Item: D2010-104

D2010-104

Parent Item Name: ARM

Start Date: 10/21/2016

Required Date: 10/28/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.02.17New issueKJ/JLM
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	70.4388	1.5	6.315789			
M304TR0 500W 049									**			FF OCT 31 2016	
304 RD Tube .500 x .049W													

Location	Loc Qty	Loc Code
GA002	70.438836	
M127937	1.1741	
M132872	29.264736	
<u>M135325</u>	40	

D2057

Manufactured No

110 Each 13.0000 1 4

D2057

Plug

**

FF OCT 31 2016

Location	Loc Qty	Loc Code
GA	13	
112928	1	
<u>141007</u>	12	

4

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Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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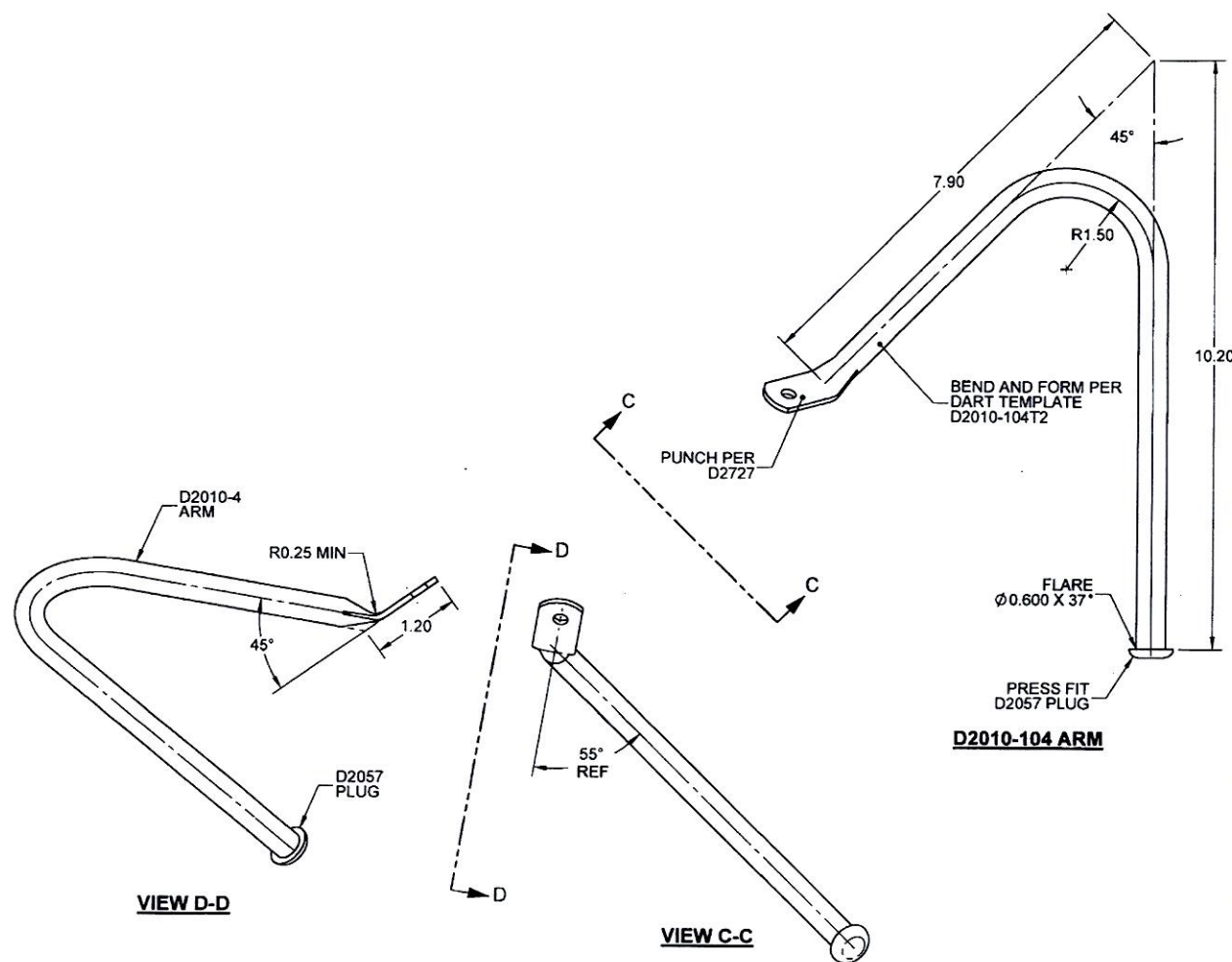
QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152158 MJS
16-10-21

RELEASED
08.06.10

- NOTES:
1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING,
Ø 0.500 X 0.049 WALL
(REF DART SPEC M304TR0.500W.049) Δ
2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART
QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING
WHITE FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	JS	D2010	SHEET 4 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD	
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VIEW D-D

VIEW C-C

D2010-104 ARM